

Work Order ID 131273

131273

Page 2

April-01-15 3:14:45 PM

Item ID: MISC P/N Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Maintenance
 Start Date: 4/01/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/08/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* Crosstubes	Memo - Degrease using 4105S Wash 'n Wipe. Use clean lint free cloth. Rinse any residue thoroughly, Wipe/dry with clean dry cloth to ensure surface contaminants removed. -Keep all surfaces clean until primed. Use clean gloves to handle. Surfaces shall be kept free from dirt, dust, finger marks, and other contaminants.	0.00				1			DAS 41 9-89 15-4-23
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00				1			DAS 38 9-89 Apr 23 2015
140 *140* SprayPaint Spray Painting	Memo <i>desoto spray white</i> - Prime and paint outside of tube per Dart QSI 005 4.2 PRIME B <u>130992</u> PAINT B <u>132024</u>	0.00				1			DAS 41 9-89 15-4-23

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Page 3

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150	QC14- Inspect Spray Paint	0.00							
150									
QC	Memo	0.00							
Quality Control									

15.04-30

MCS
closed at ϕ
MAY 13 2015

Linda Lacelle

From: Chris Provencal
Sent: April-01-15 1:32 PM
To: Linda Lacelle
Cc: Patrick Smith; Laith Qatami
Subject: Samples for adhesion test

Linda,

We need work orders to prepare two sample pieces, one work order per sample. The goal is to prepare them as we would during production, with the exception of the bending. We should be able to use end pieces from the extrusion and still have enough left over to use the extrusion in normal production.

1st Sample, Prime and Paint

- 131273
- Pick D6021 extrusion
 - Machine to Ø2.300 OD x 6" long
 - Grind surface smooth using GR80 drum belt and finish with a coarse Blendex™ drum (Walter Surface Technologies). Circumferential grind marks are unacceptable.
 - Inspection
 - Degrease using 4105S Wash 'n Wipe. Use clean lint free cloth. Rinse any residue thoroughly, Wipe/dry with clean dry cloth to ensure surface contaminants removed.

Keep all surfaces clean until primed. Use clean gloves to handle. Surfaces shall be kept free from dirt, dust, finger marks, and other contaminants.

- Prime and paint outside of tube per Dart QSI 005 4.2
- Inspection

2nd Sample, Powder Coat

- 131274
- Pick D6021 extrusion
 - Machine to Ø2.300 OD x 6" long
 - Grind surface smooth using GR80 drum belt and finish with a coarse Blendex™ drum (Walter Surface Technologies). Circumferential grind marks are unacceptable.
 - Inspection
 - Degrease using 4105S Wash 'n Wipe. Use clean lint free cloth. Rinse any residue thoroughly, Wipe/dry with clean dry cloth to ensure surface contaminants removed.

Keep all surfaces clean until primed. Use clean gloves to handle. Surfaces shall be kept free from dirt, dust, finger marks, and other contaminants.

- Powder coat "White Gloss" per Dart QSI 005 4.3.5.2
- Inspection